

# Work Order ID 69852

Friday, May 20, 2011 10:39:53 AM



Page 1

Item ID: D4037-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Crossbeam

Start Date: 5/20/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: CL

Date: 11/05/20

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4037

CUR

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

Cut blank as per file D4037-3\_BLANK

0.00

B 11-5-24

2

110

0.00



HAAS I

HAAS CNC vertical machine #1

Memo

MACHINE AS PER FOLI FA878 AND DWG

FOLIO REV: AA

DWG REV: D

0.00

SL 11/06/06

2

DEBURR

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D4037-3

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Item Name: Fwd Crossbeam

Start Date: 5/20/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00 0.00	SL	11/06/06	②				
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00		ent 11/06/07		2	10		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00							2x $\phi$ m-p 11/06/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 69852

Friday, May 20, 2011 10:39:53 AM



Page 3

Item ID: D4037-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Crossbeam

Start Date: 5/20/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Start Time: 9:30

Temp: 320 OF

Finish Time: 10:00

2X ~~Ø~~ M-11/06/09



Powdercoat

Memo

Powder Coating

M 116964

160

QC3- Inspect Part Finish

0.00



QC

Memo

Quality Control

2 ~~Ø~~ PK 11.6 9

170

Identify as per dwg & Stock Location: ST200

0.00



Packaging

Memo

Packaging

0.00

10/11/09 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 69852**

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Item ID: D4037-3

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Setup Start



Revision ID:

Stop



Item Name: Fwd Crossbeam

Start Date: 5/20/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/11

CL 11/06/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Friday, May 20, 2011 10:39:50 AM

Page 1

Work Order ID: 69852

Parent Item: D4037-3

Parent Item Name: Fwd Crossbeam



Start Date: 5/20/2011

Required Date: 6/10/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 09-12-14 JLM VERIFIED BY:EC IPP  
REV:B AS PER REV B 10-04-19 JLM VERIFIED BY:EC IPP REV  
C:AS PER ECN 10-563 10-09-28 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

~~M0061T6B1.000X15.00~~  
0

Purchased

No

100

f

39.0000

3.9

8.210526



~~0061-T6 Bar 1.00 x 15.00~~



1811-5-24

Location

Loc Qty

Loc Code

MAT005

39

115173

12

117372

24

9544

3

117372

2

*[Handwritten signature]*

D

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

158  
.196

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	69852
<b>Description:</b> Fwd Crossbeam		<b>Part Number:</b>	D4037-3
<b>Inspection Dwg:</b> D4037	<b>Rev:</b> <del>C</del> D	Page 1 of 1	

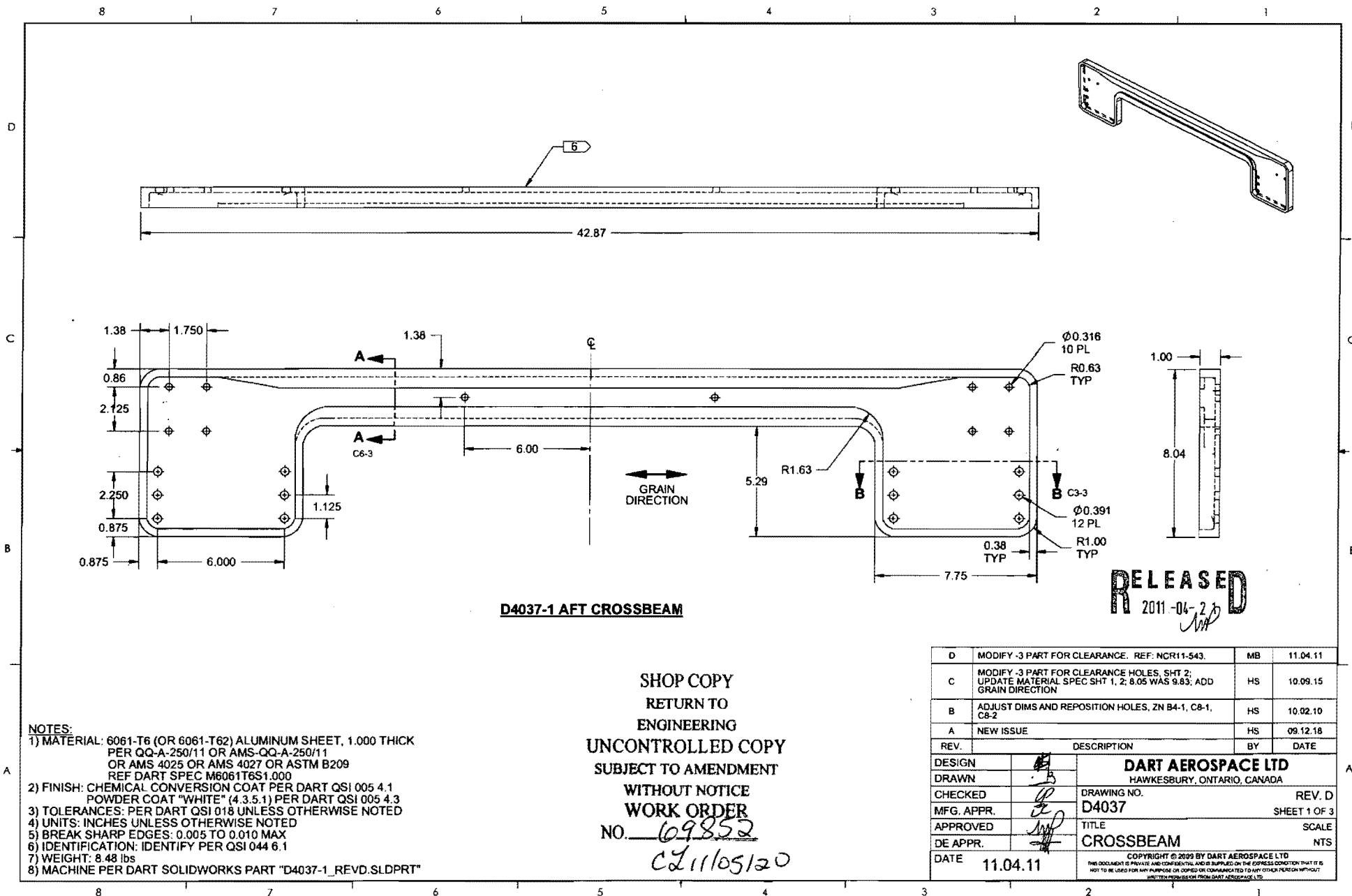
### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
41.66	+/-0.030	41.66	/		mic	
0.92	+/-0.030	.919	/		mic	
1.75	+/-0.030	1.750	/			
0.92	+/-0.030	.918	/			
2.125	+/-0.010	2.125	/			
Ø0.316	+0.006/-0.001	.316	/			
Ø0.391	+0.006/-0.001	.391	/			
0.28	+/-0.030	.282	/			
1.32	+/-0.030	1.330	/			
7.79	+/-0.030	7.788	/		H-G	
5.80	+/-0.030	5.80	/			
2.250	+/-0.010	2.250	/			
0.875	+/-0.010	.874	/			
6.000	+/-0.010	6.000	/			
7.75	+/-0.030	7.752	/		VRNCNC-02	
1.125	+/-0.010	1.125	/			
9.29	+/-0.030	9.292	/		VRNCNC-02	
1.75	+/-0.030	1.750	/			
1.38	+/-0.030	1.375	/			
1.50	+/-0.030	1.498	/			
0.63	+/-0.030	.625	/			
1.00	+/-0.030	1.006	/			
10.79	+/-0.030	10.793	/		H-G	
3.00	+/-0.030	3.003	/			
2.00	+/-0.030	2.004	/		mic	
0.25	+/-0.030	.255	/		mic	
0.530	+/-0.010	.525	/			
0.35	+/-0.030	.360	/			
0.35	+/-0.030	.360	/			
R0.13	+/-0.030	.125	/			

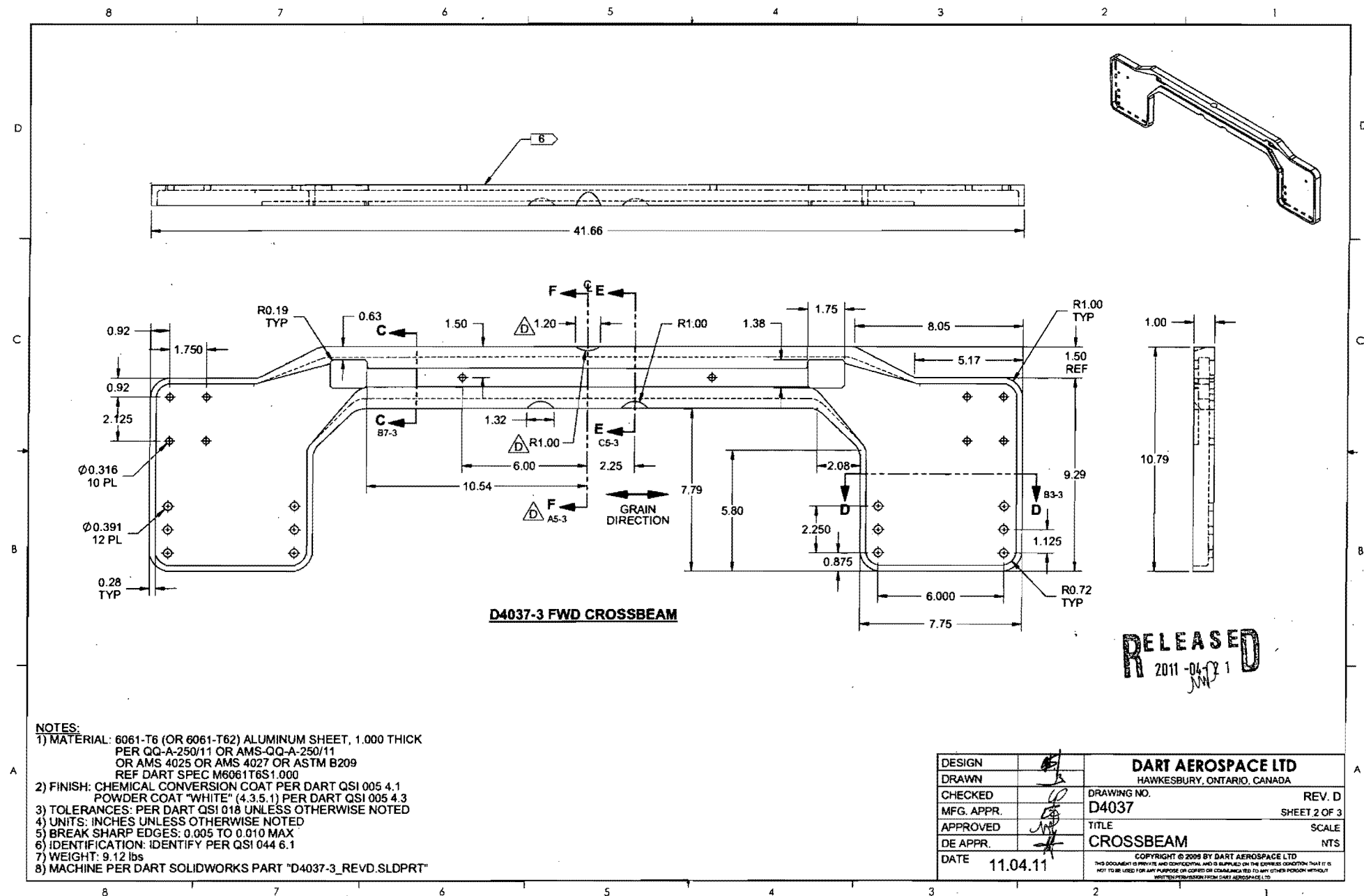
<b>Measured by:</b> SL	<b>Audited by:</b> amf	<b>Preliminary Approval:</b>
<b>Date:</b> 11/06/06	<b>Date:</b> 11/06/07	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	10.06.08	New Issue	KJ	
B	10.10.07	Dimensions updated per Dwg Rev C	KJ	



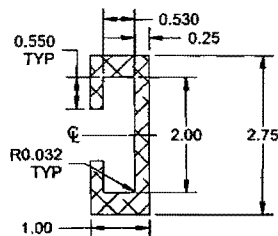




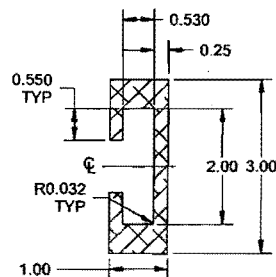




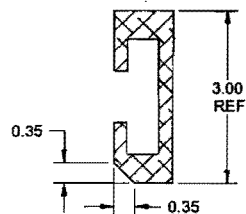




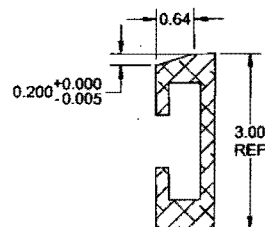
**SECTION A-A** B6-1  
SCALE 2X



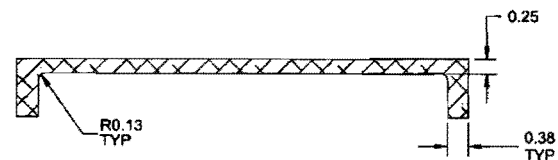
**SECTION C-C** B6-2  
SCALE 2X



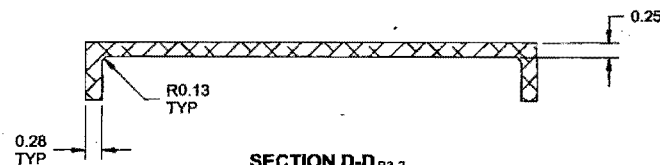
**SECTION E-E** C5-2  
SCALE 2X



**SECTION F-F** B5-2  
SCALE 2X



**SECTION B-B** B2-1  
SCALE 2X



**SECTION D-D** B3-2  
SCALE 2X

**RELEASED**  
2011-04-31  
JW

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D4037</b>	REV. D
MFG. APPR.			SHEET 3 OF 3
APPROVED		TITLE <b>CROSSBEAM</b>	SCALE
DE APPR.			NTS
DATE	11.04.11	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

